

Work Order ID 61194

Wednesday, August 11, 2010 10:03:53 AM



Page 1

Item ID: D3278-1

Accept



Setup Start



Revision ID:

Item Name: Support

Stop



Start Date: 8/11/2010 Start Qty: 30.00



Cust Item ID:

Required Date: 8/25/2010 Req'd Qty: 30.00

Customer:

Reference:

Approvals: Process Plan: MF Date: 10-8-11

Tooling:

Date:

Run Start



QC: Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3278 | Rev C | | | | | | | | |

100

0.00



BAND SAW

0.00

Bandsaw

Memo

mf 10/08/16

30 0

Jeaspa Bandsaw

Cut blank: 2.00" x 1.00" x 2.550" long

110

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

mf 10.8.17

30 0

HAAS CNC vertical machine #1

1- Machine as per Folio FA405 and Dwg D3278-1
2- Deburr and Tumble
Identify as D3278-1

mf 10.8.18

120

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

30 0

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 61194

Wednesday, August 11, 2010 10:03:53 AM



Page 2

Item ID: D3278-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Support

Start Date: 8/11/2010 Start Qty: 30.00



Cust Item ID:

Required Date: 8/25/2010 Req'd Qty: 30.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

130

QC8- Inspect parts - second check

0.00



DP 10/24/18

QC

Memo

0.00

30

0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

ml

10

08

19

30

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



m 115891

Powdercoat

Memo

0.00

Powder Coating

START TIME:

11:15

OVEN TEMPERATURE:

FINISH TIME:

11:45

30

10-8-24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 61194

Wednesday, August 11, 2010 10:03:54 AM

Page 3

Item ID: D3278-1

Accept

Revision ID:

Item Name: Support

Start Date: 8/11/2010 Start Qty: 30.00

Required Date: 8/25/2010 Req'd Qty: 30.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

7/11

10/08/24

30

0

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 45

0.00

Packaging

Memo

0.00

Packaging

10/8/24 sf 300

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/08/26 J
CZ 10/8/25

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, August 11, 2010 10:03:53 AM

Page 1

Work Order ID: 61194



Parent Item: D3278-1

Parent Item Name: Support

Start Date: 8/11/2010

Required Date: 8/25/2010

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP: ☐A ☐04.04.19 ☐New issue ☐KJ/JLM ☐
IPP B 07.09.06 rev.c dwg EC verified by: JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B1.000X02.00 0 | | Purchased | No | | | 100 | f | 50.4220 | 0.2337 | 7.38 | | | |



6061-T6 Bar 1.00 x 2.00



| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT | 48.192 | |
| 112567 | 0 | |
| 115045 | 48.192 | |
| MAT03 | 2.23 | |
| 112567 | 2.23 | |

7.38 *mf 10/08/16*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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|------------------------------|---------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 61194 |
| Description: Support | | Part Number: D3278-1 |
| Inspection Dwg: D3278 | Rev: C | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.098 | +0.005/-0.000 | .098 | / | | Vern | |
| 0.359 | +/-0.005 | .359 | / | | " | |
| 0.609 | +/-0.010 | .613 | / | | " | |
| 0.250 | +/-0.010 | .250 | / | | " | |
| 1.480 | +/-0.005 | 1.480 | / | | " | |
| R0.125 | +/-0.010 | .125 | / | | Rad gage | |
| 0.119 | +0.005/-0.004 | .120 | / | | Mic. | |
| 2.439 | +/-0.010 | 2.440 | / | | Vern. | |
| 1.980 | +/-0.010 | 1.982 | / | | " | |
| R0.13 | +/-0.030 | .130 | / | | Rad gage | |
| Ø0.257 | +0.005/-0.000 | .258 | / | | Vern. | |
| R0.375 | +/-0.010 | .375 | / | | Rad gage | |
| 0.875 | +/-0.010 | .875 | / | | Vern. | |
| 0.500 | +/-0.010 | .500 | / | | " | |
| R0.400 | +/-0.010 | .400 | / | | Rad gage | |
| R1.00 | +/-0.030 | 1.00 | / | | Rad gage | |
| 1.720 | +/-0.010 | 1.723 | / | | Vern | |
| R0.125 | +/-0.010 | .125 | / | | Rad gage | |
| 0.125 | +/-0.010 | .128 | / | | Vern. | |

| |
|--|
| Measured by: <i>[Signature]</i> |
| Date: 10.8.18 |

| |
|---------------------------------------|
| Audited by: <i>[Signature]</i> |
| Date: 10/08/18 |

| | |
|----------------------------|-----|
| Prototype Approval: | N/A |
| Date: | N/A |

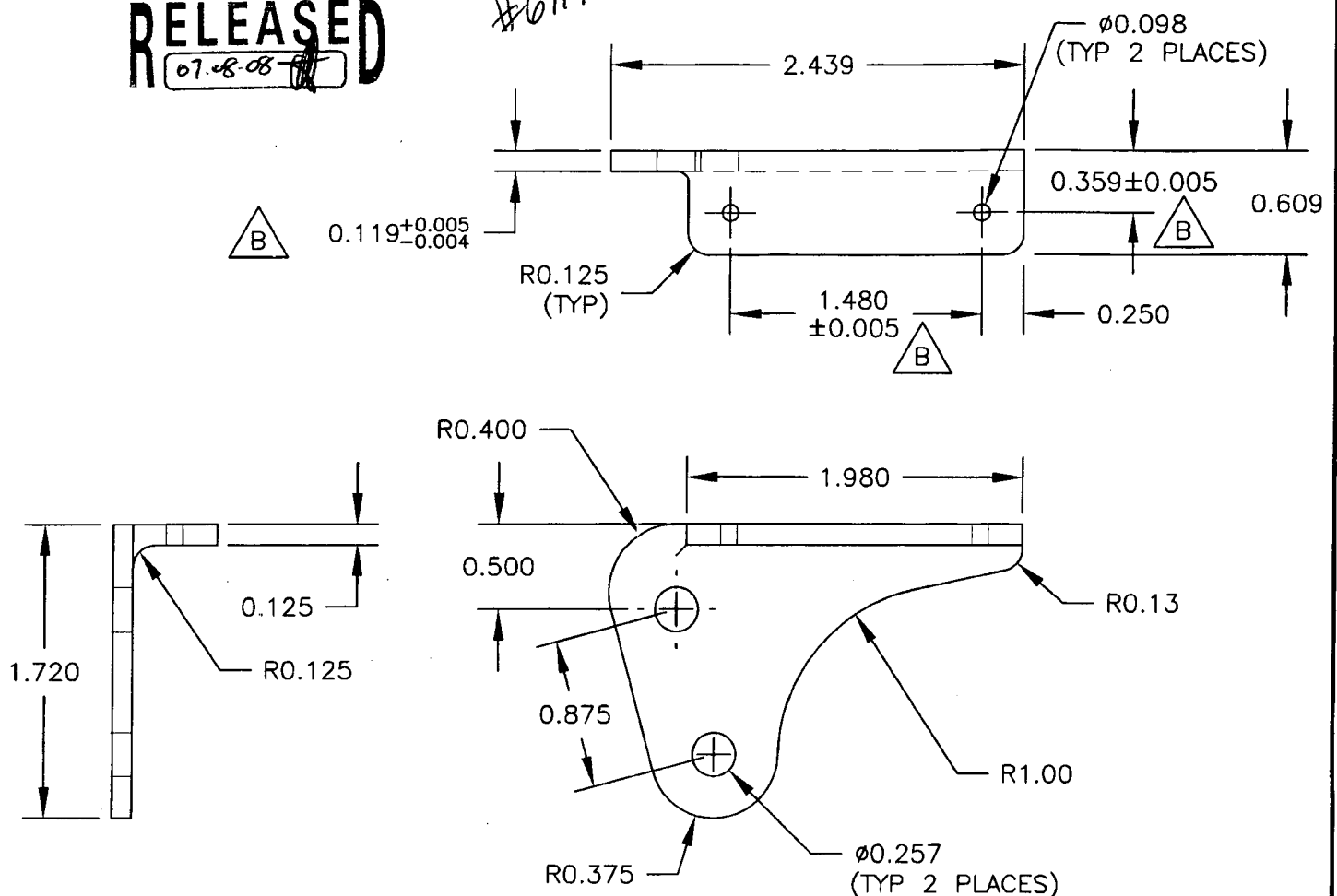
| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------------------------------|--------------------------|--------------------|
| A | 04.04.19 | New Issue P/O D3278-041 | KJ/JLM | |
| B | 05.06.08 | 0.359 was 0.365; 0.119 was 0.125 | KJ/JLM | |
| C | 07.09.26 | Dimensions updated per Dwg Rev. C | KJ/EC <i>[Signature]</i> | <i>[Signature]</i> |

DART

| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>90</i> | DRAWN BY <i>BC</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3278 | REV. C SHEET 2 OF 3 |
| DATE 07.07.24 | | TITLE SUPPORT ASSEMBLY | SCALE 1:1 |

RELEASED
07.08.08

#61194

**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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